

Work Order ID **126244**

126244

Page 1

Tuesday, November 04, 2014 10:22:44 AM

Item ID: 647.4313 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: RH Upper Strut
 Start Date: 11/4/2014 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/4/2014 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11-11-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.4300	A								

110

110

Waterjet
FLOW CNC Waterjet

Memo

1-Cut 647.4312 plate 3.928X1.985 as per Dwg
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

0.00

0.00

(25)

Dec 14/11/25

120

120

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

(25)

Dec 14/11/25

SCHAP

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(25)			38 9-89 NOV 26 2014
140 *140* Small Fab Small Fab	Memo 1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

P.T.O.

DQA: Date: JAN 5 2011

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: <u>126244</u> Part No. <u>647.4313</u> NCR No. <u>16-6192</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐	
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Large Fab ☒	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐	16-12-16	140	25	Part been sitting on shelf since novembre 2014 material rusted	DAS 9 9-89	Scrap → destroy.	DAS 9 9-89 16-12-16		
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☒									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☒ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R 4130 rod Batch: _____	0.00							
Large Fab	Memo Weld tube to plate as per dwg. Weld end were tube is punch.	0.00							
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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126244

Page 5

N900040100

Setup Start *NS1*

Stop ***NS2***

Customer:

20

20

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, November 04, 2014 10:22:47 AM

Page 1

Work Order ID: 126244

126244

Parent Item: 647.4313

647 4313

Parent Item Name: RH Upper Strut

Start Date: 11/4/2014

Required Date: 11/4/2014

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NS.063

Purchased

No

110

sf

17.3000

0.054

2

M4130NS 063

4130 Sheet .063

DC 14/11/24

Location

Loc Qty

Loc Code

MAT019

17.3

125079

17.3

1.5937

M4130NT0.500W.049

Purchased

No

140

f

460.8720

1.83

39

M4130NT0 500W 049

4130 RD Tube .500 x.049W

Location

Loc Qty

Loc Code

MAT032

460.872

m127111

27.07

m128713

21.135

m129826

216

m130551

196.667

DQA: _____ Date: _____



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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04048

SHEET 1 OF 1

DWG NO. 647.4300

REV: N/C

PREPARED
BY

D. PETERS

DATE: 08/12/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: STRUT

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR:

NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126244 MWS
14-11-07

DOCUMENTS EFFECTED:

☐ RFMS

☐ MDL

☐ INSTALL INSTRU

☐ ICA

☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

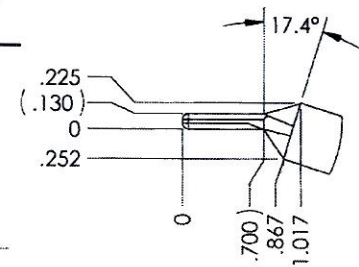
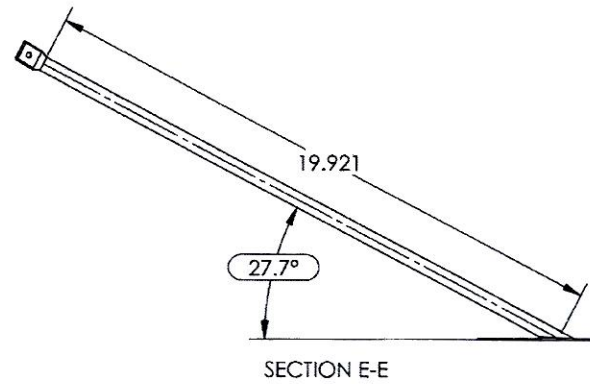
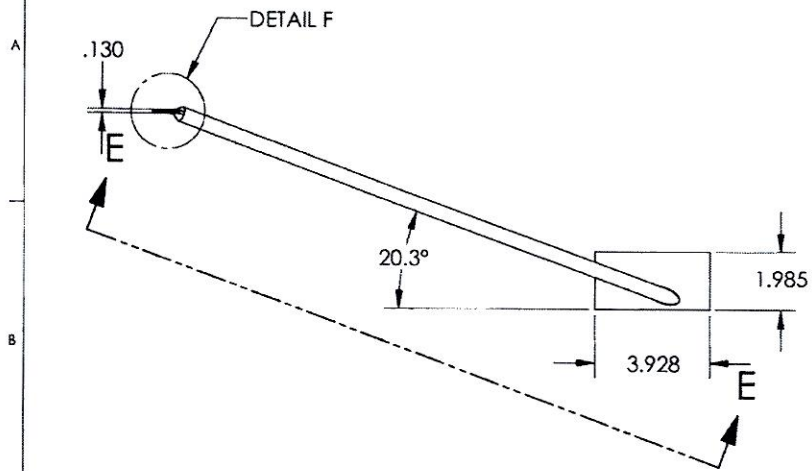
☐ YES

☒ NO

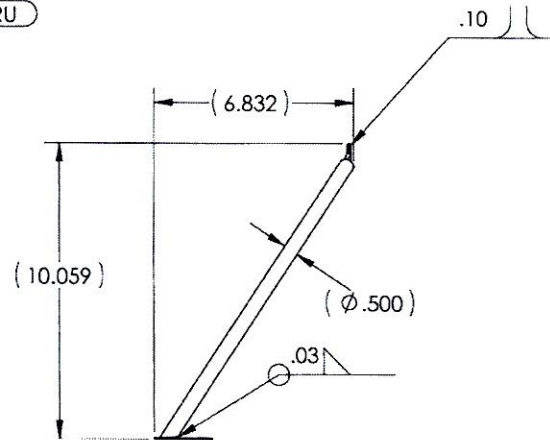
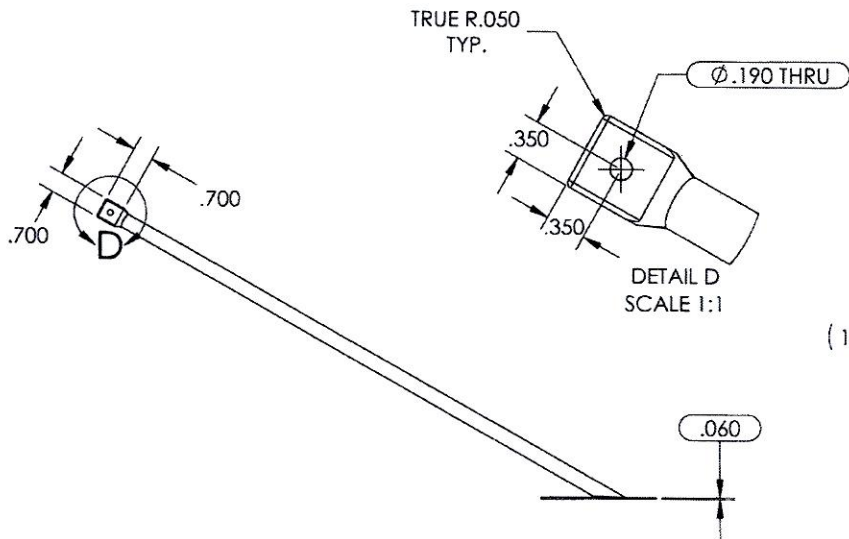
NOTES: UNLESS OTHERWISE SPECIFIED

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DETAIL F
SCALE 1:1
SHOWN NORMAL TO SIDE OF TAB



ORIGINAL DATE 10/07/09		APICAL INDUSTRIES	
DRAWN BY R. POJANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY D. BARNER		STRUT	
DRAWING APPROVAL P. BRAVO		SCALE: NONE	
CUTTING No.		SHEET 2 OF 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET 07/MZ6	REV. A